

Work Order ID 82619

82619

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Item ID: D412-698-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller, LH

Start Date: 03/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								

100

100

DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

JB S 2/24/12

42/BG 12-4-13

110

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

2

12/04/13

120

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

S 2/24/12

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 18/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-011								
	Location: <u>62</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

24 12/4/24

12/4/26

ME
12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 03/04/2012

Required Date: 18/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141		Manufactured	No			100	Each	12.0000	3	6			
<div> <div>S</div> <div>*D3121-141*</div> <div>Bracket Assembly</div> </div>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235				12					
				80097				12		80097			
D3121-143		Manufactured	No			110	Each	8.0000	1	2			
<div> <div>S</div> <div>*D3121-143*</div> <div>Bracket Assembly</div> </div>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				8					
				75031				4		75031			
				80098				4					
D3183-043		Manufactured	No			110	Each	3.0000	1	2			
<div> <div>S</div> <div>*D3183-043*</div> <div>Bracket Assembly</div> </div>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235				3					
				75033				3		75033			
D3137-043		Manufactured	No			110	Each	6.0000	1	2			
<div> <div>S</div> <div>*D3137-043*</div> <div>Bracket Assembly</div> </div>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				6					
				79734				6					

JB

JB

JB

JB

12/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82619

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Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 03/04/2012

Required Date: 18/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

12.0000

9

18

**

D3199-1

Bracket

B8206951

Location

Loc Qty

Loc Code

ST236

17

78618

4

79797

8

ST236A

-5

110

Each

8.0000

1

2

**

D3202-1

Manufactured No

D3202-1

Cover

JB

12/04/13

Location

Loc Qty

Loc Code

ST241A

8

70294

8

70294

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01